

Date: Thursday, 2/22/2007 2:57:30 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|-------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : WEARPLATE |
| Job Number | : 30812 | | |
| Estimate Number | : 10299 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D25775 |
| This Issue | : 2/22/2007 | S.O. No. | : <i>N/A</i> |
| Prsht Rev. | : NC | Drawing Number | : D2577 REV E |
| First Issue | : <i>N/A</i> | Project Number | : N/A |
| Previous Run | : 28639 | Drawing Revision | : E |
| | | Material | : <i>N/A</i> |
| Written By | : | Due Date | : 3/15/2007 |
| Checked & Approved By | : <i>JA 07.02.23</i> | Qty: | <i>39</i> / 30 Um: Each |
| Comment | : Est: P 02.09.24 Re-format KJ/RF Est Rev:D Now on Waterjet 06-06-14 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|------------|-------------------------|
| 1.0 | M1010S16GA | 1010/1025/A21/6aA SHEET |
|-----|------------|-------------------------|



Comment: Qty.: 1.0301 sf(s)/Unit Total : 30.9015 sf(s)

1010/1025 16GA SHEET

(m1010s16ga)

Batch:

421
M104000A (3)

SAU

07/05/14

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D2577

Dwg Rev: *E*Prog Rev: *E*

SAU 07/05/14

(34)

2-Deburr if necessary

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2577-5T1

SAD 07/05/14

(34)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

07-05-15 (34)

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAU 07/05/22

(34)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ER Date: 07/05/13
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:57:30 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 30812

Part Number: D25775

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

SB 07/05/25

(34)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20528

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 101601

BR/M/L 07/05/29

(34)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 07/05/30

(34)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

a.m 07/05/30

(34)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/31

(31)

Job Completion



07/05/31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



RELEASED
00.09.22

| DESIGN | DRAWN BY | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | REV. E |
|---------------|----------------|---|--------------|
| CHECKED | APPROVED | DRAWING NO. D2577 | SHEET 1 OF 5 |
| DATE 00.09.22 | TITLE WEARSHOE | SCALE 1:10 | |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.04 | ADD HARDCOAT WELDS | |
| C | 97.05.30 | CHANGE HOLES TO OBROUNDS | |
| D | 98.08.17 | CORRECTED DIMENSIONS ON -1 & -3 | |
| E | 00.09.22 | ADD D2577-101/-11/-13 INCORPORATE DE09176 | |

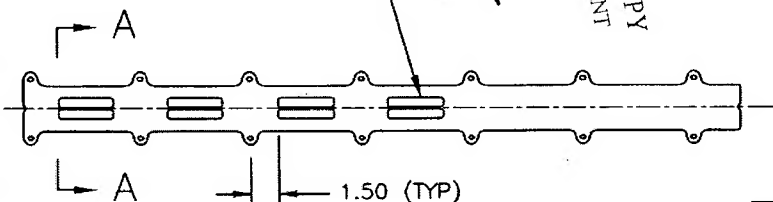
7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



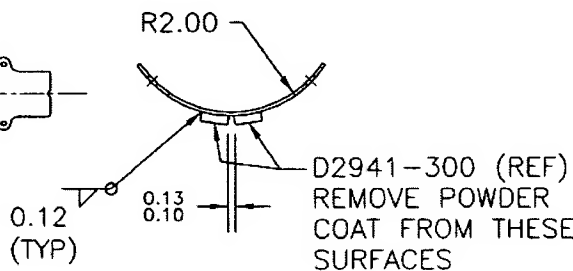
D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30812

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



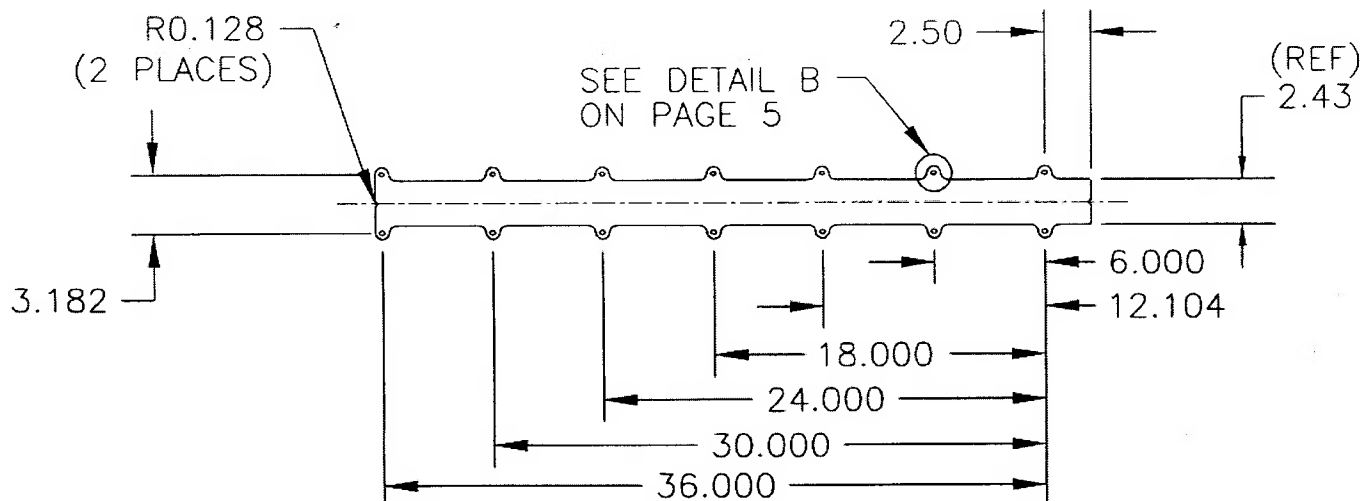
SECTION A-A
SCALE 1:5



D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



| | | | |
|------------------|----------|---|---------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | REV. E |
| CHECKED | APPROVED | DRAWING NO. D2577 | SHEET 2 OF 5 |
| DATE 00.09.22 | | TITLE WEARSHOE | SCALE 1:10 |



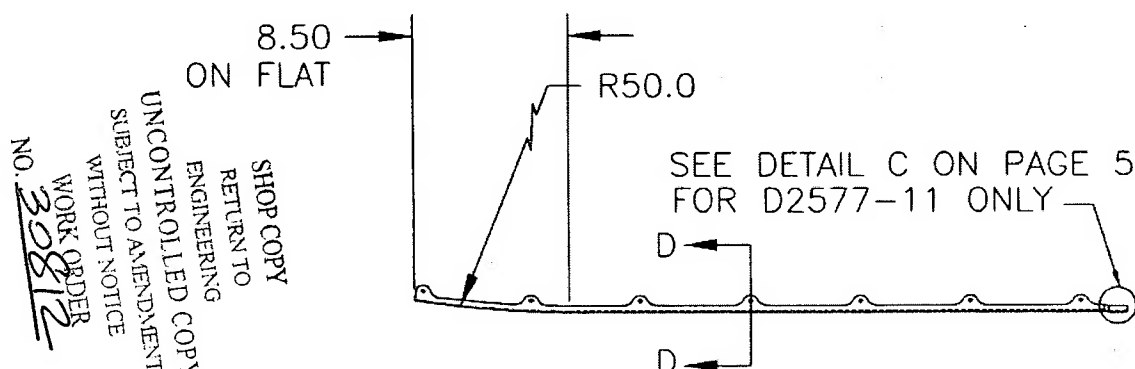
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00.09.22

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WORK ORDER
NO. 30812



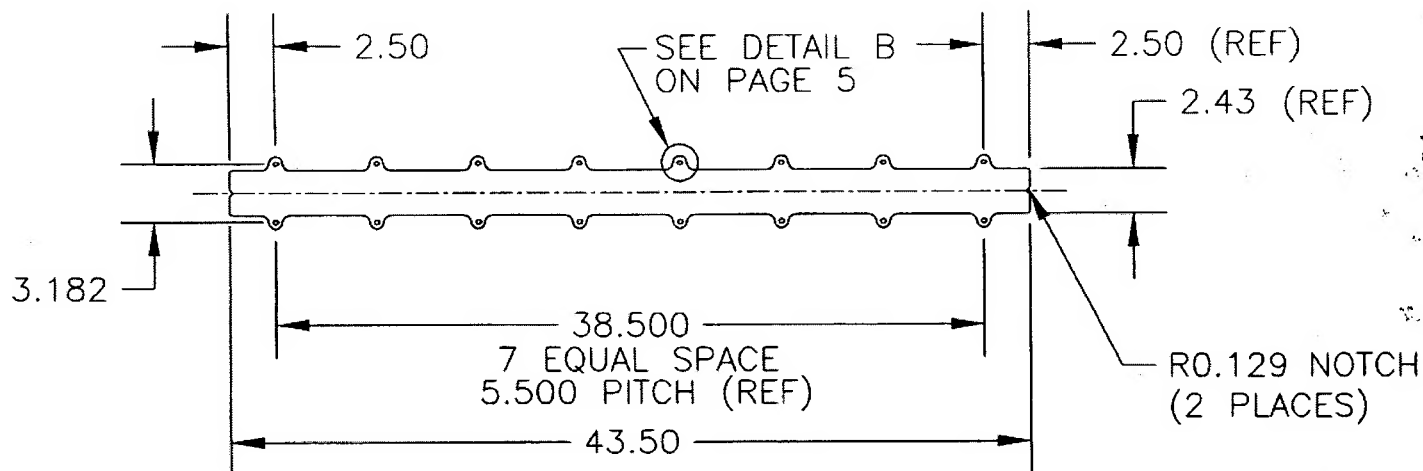
DART



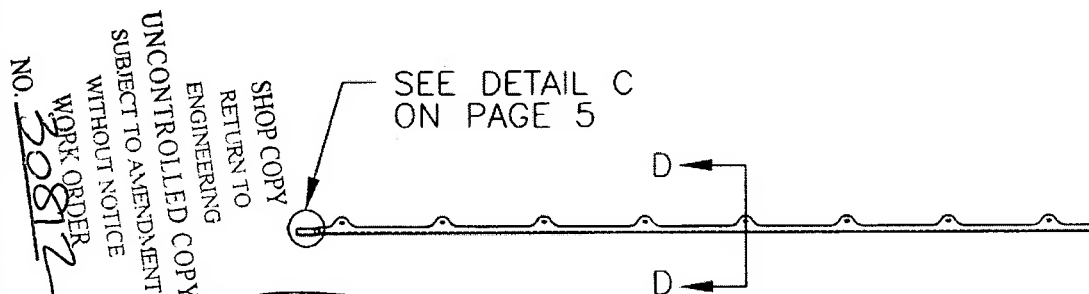
| | | | | |
|---------|----------|----------|----------|---|
| DESIGN | ✓ | DRAWN BY | CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | ✓ | APPROVED | ✓ | DRAWING NO. D2577 |
| DATE | 00.09.22 | TITLE | WEARSHOE | REV. E |
| | | SCALE | 1:10 | SHEET 3 OF 5 |

RELEASED
00.09.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



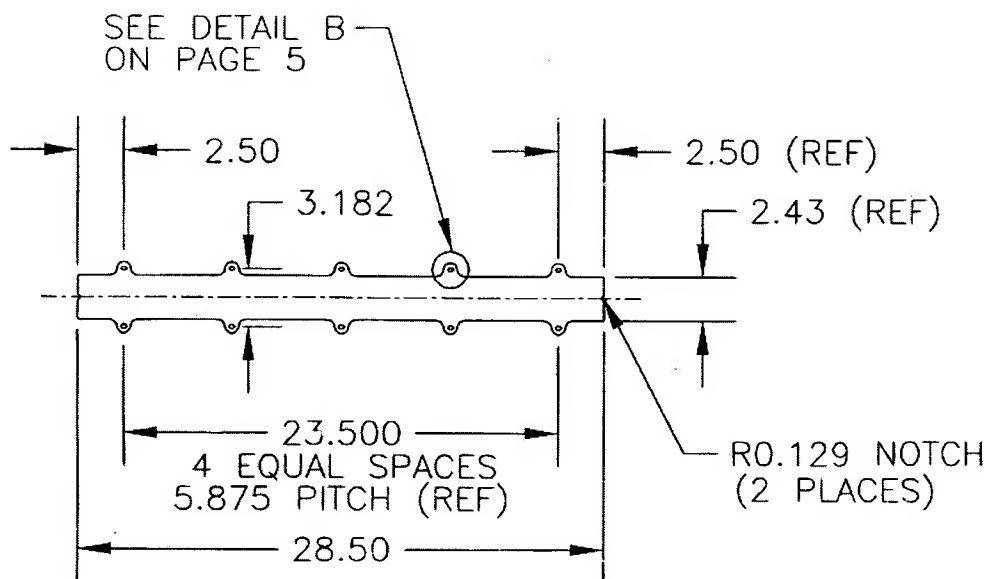
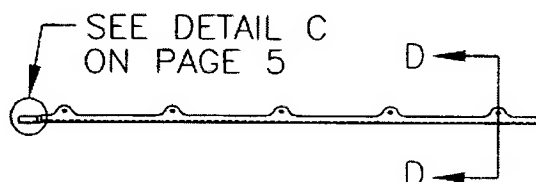
D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
 SERIES STEEL 0.063 THICK
 FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 20812
 WORK ORDER

DART

| | | | | |
|----------|----------|---|--------------|-------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA | | |
| CHECKED | APPROVED | DRAWING NO. | REV. E | |
| DATE | | D2577 | SHEET 4 OF 5 | |
| 00.09.22 | | TITLE | WEARSHOE | SCALE |
| | | | | 1:10 |

RELEASED
00.09.26D2577-7 FLAT PATTERND2577-7 LONGITUDINAL BEND

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WITHOUT NOTICE
WORK ORDER
NO. 30812

D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

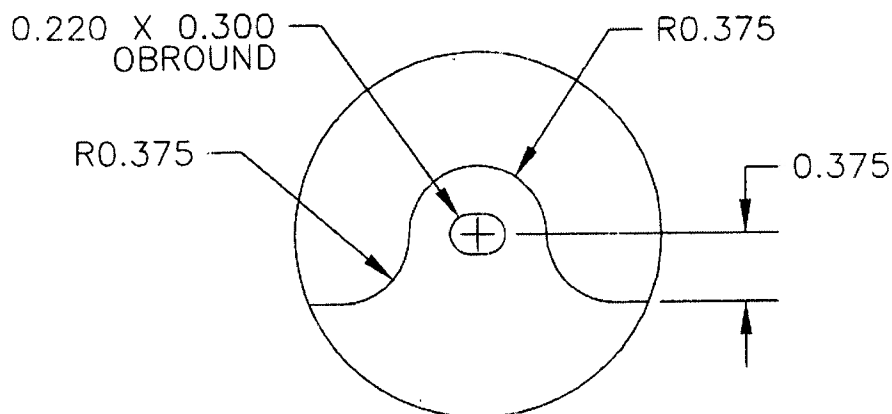
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



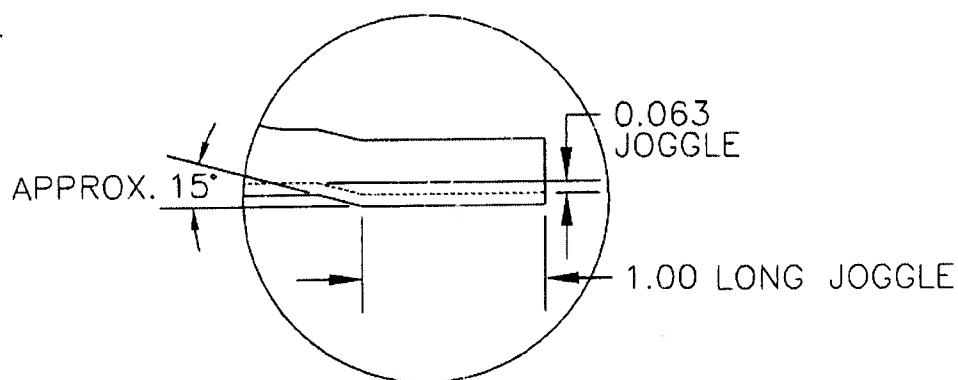
| | | | |
|------------------|----------------|---|------------------------|
| DESIGN # | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2577 | REV. E SHEET 5 OF 5 |
| DATE 00.09.22 | | TITLE WEARSHOE | SCALE 1:10 |

DETAIL B (SCALE 1:1)

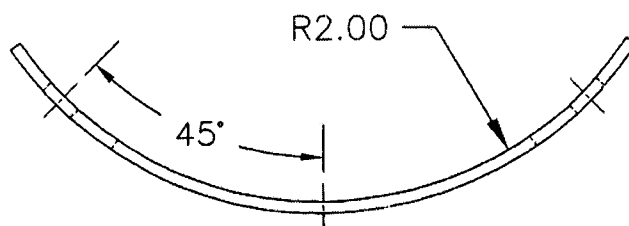
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00.09.26



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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